

Work Order ID 165886

Tuesday, September 05, 2017 7:25:54 AM

*LSAP****165886***

Page 1

Item ID: D3413-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: O-Ring

Start Date: 9/5/2017 Start Qty: 30.00

30

Cust Item ID:

Required Date: 9/15/2017 Req'd Qty: 30.00

30

Customer:

Reference:

Approvals: Process Plan: *[Signature]* Date: _____ Tooling: _____ Date: _____Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D3413	Rev A
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100

0.00

100

FLOW WATER JET

Waterjet

Memo

1.83

FLOW CNC Waterjet

1-Cut as per Dwg D3413

Dwg Rev: *A*Prog Rev: *A*

2- Deburr and drill hole if required as per dwg D3413 & QSI018 4.1 .

*30**17/09/07*DAS
40
9-89

110

0.00

110

QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.60

Quality Control

*30**17/09/07*DAS
40
9-89

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Item ID: D3413-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: O-Ring
 Start Date: 9/5/2017 Start Qty: 30.00 ***30*** Cust Item ID:
 Required Date: 9/15/2017 Req'd Qty: 30.00 ***30*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.60				<u>35</u>	<u>1709-11</u>		DAS 9 9-89
150 *150* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum <u>M138014</u> Memo START TIME: <u>9:40</u> OVEN TEMPERATURE: <u>400°</u> FINISH TIME: <u>10:10</u>	0.00 0.61				<u>30</u>	<u>φ 1709-12</u>		DAS 94 9-89
160 *160* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.60				<u>30</u>			SEP 14 2017 DAS 6 9-89

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Item ID: D3413-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: O-Ring
Start Date: 9/5/2017 Start Qty: 30.00 ***30*** Cust Item ID:
Required Date: 9/15/2017 Req'd Qty: 30.00 ***30*** Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Identify as per dwg & Stock Location: <u>ST530</u>	0.00							
170						<u>30</u>	<u>DAS</u> <u>6</u>		<u>SEP 14 2017</u>
Packaging	Memo	3.00					<u>9:09</u>		
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.30							<u>17/9/19</u> <u>JS</u>
Quality Control									

DAS
21
9-89

SEP 14 2017

Picklist Print

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Work Order ID: 165886

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Parent Item: D3413-1

D3413-1

Parent Item Name: O-Ring

Start Date: 9/5/2017

Required Date: 9/15/2017

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP Rev:A05.09.13New issueKJ/JLM
IPP Rev:B Now on Waterjet 07-05-28 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B0.250X4.000		Purchased	No			100	f	9.6000	0.25	7.894737			
M304B0 250X4 000									**				
												17/09/07	DAS 40 9-89

304 BAR .250 x 4.00

Location

Loc Qty

Loc Code

MAT009

9.6

M137762

9.6

~~9.6~~

DART AEROSPACE LTD		Work Order:	165886
Description: Ring		Part Number:	D3413-1
Inspection Dwg: D3413 Rev: A			Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X

First Article

X

Prototype

[illegible]

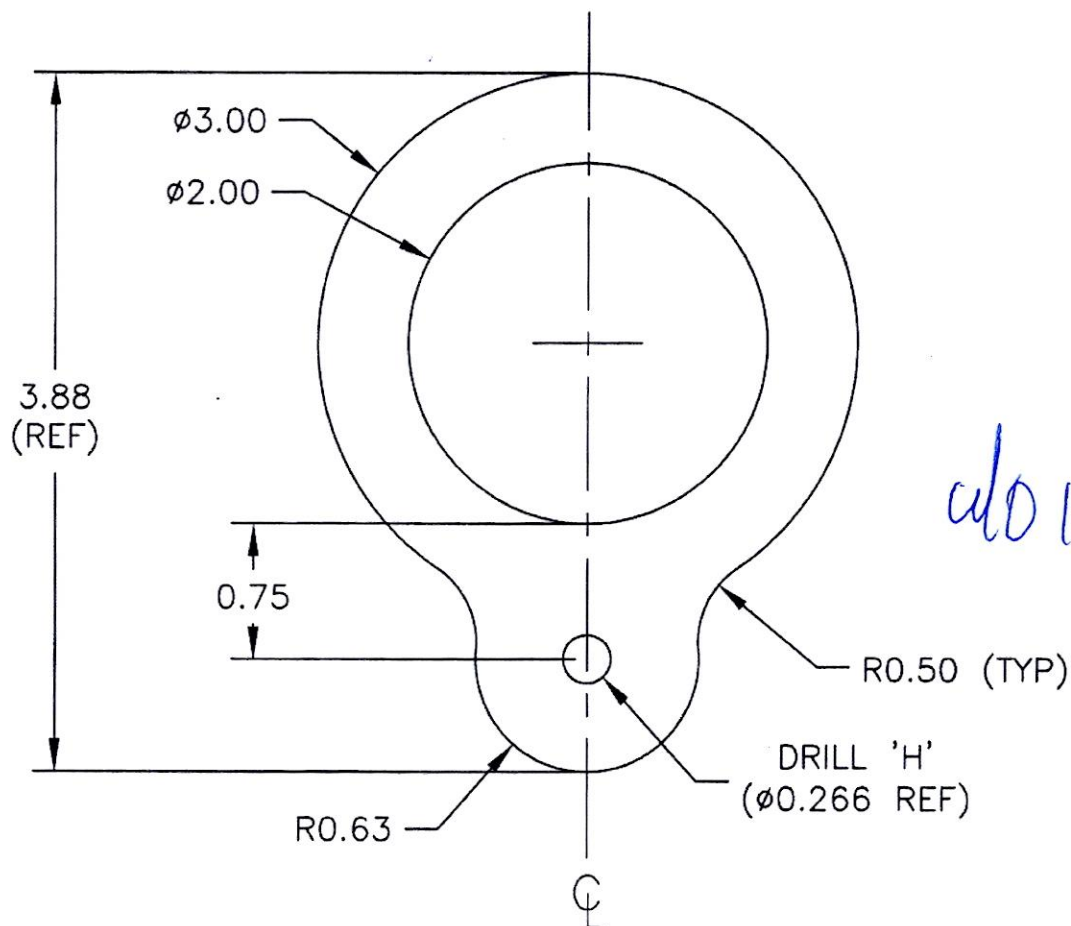
Measured by:	40	Audited by:	9	Prototype Approval:	N/A
Date:	17/09/17	Date:	17-09-11	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.09.06	New Issue	KJ/JLM	



DESIGN CP	DRAWN BY CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3413	REV. A SHEET 1 OF 1
DATE 05.03.16		TITLE RING	SCALE 1:1
A	05.03.16	NEW ISSUE	

RELEASED
05-09-06 *[Signature]*



u/d 165886

D3413-1 RING

- 1) MATERIAL: AISI 304/316 SS PLATE, 0.250 THICK (REF DART SPEC. M304S3GA)
- 2) FINISH: POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) DEBURR ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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